



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2432
Job Sheet 202735



Part No: D2432

Job Qty: 24 pcs

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Due Date: 11/26/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	24		11/26/19	0.00	0.00	Purchasing - 1		NOV 11 2019
		pcs					Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	24		11/26/19	0.00	0.00	Packaging 2 - 1 - B4B		NOV 11 2019
		pcs					Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230529



Part: D2432

Job No: 202735

Serial No/Batch: S230529

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/11/19

Plex 11/1/19 10:48 AM dart.lacelle.linda

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
110 QC 6	24 pcs	11/26/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	81
				QC 6 - 40	9-89
				QC 6 - 81	DAS
130 HAAS 4 Axis - B4B	24 pcs	11/26/19	1.00 30.04	HAAS - 1 - B4B	52
				HAAS - 2 - B4B	9-89
				HAAS - 3 - B4B	
				HAAS - 4 - B4B	
140 QC 2	24 pcs	11/26/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	

				QC 2 - 50	
				QC 2 - 51	DAS
				QC 2 - 52	52
				QC 2 - 57	9-89
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
150 QC 8	24 pcs	11/26/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	DAS
				QC 8 - 23	23
				QC 8 - 57	9-89
				QC 8 - 76	
				QC 8 - 61	
160 Packaging 3-1 - Stock - B4B	24 pcs	11/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC. ST 445
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B					
Packaging 3 - 36 - B4B					
170 QC 21 - SA	24 pcs	11/26/19	0.00 0.00	QC 21 - SA - 21	DA3
				QC 21 - SA - 70	2 NOV 25 2019
				QC 21 - SA - 53	2-50
Part Op 90 - 1-Issue PO: 44901 2-Cut blanks as per D2432_NEST7 file. Descriptions: 100 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.) 110 - (QC6- All purchased or subcontracted products) 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location:) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2432P	Bearpaw 19" X 24"	24 Ea (1 ea)	90-Purchasing	5230576	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	88.8000 sf (3.7 ea)	90-Purchasing	5228711	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D2432P	24	0	0
	MUHMWB10	89	666	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044981



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044981
PO Date: 11/1/19
Due Date: 11/15/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms: Prepaid
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202736	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X74		11/15/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24
											DAS 81 9-89	NOV 11 2019		
2	202735	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X74		11/18/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24
												NOV 11 2019		
3	202734	D4355-1P	D4355 Rev B			Bearpaw - cut blanks as per D4355-1 file	Firmed X6		11/15/19	6 Ea	0 Ea	6 Ea	\$44.88/Ea	\$269.28
												NOV 11 2019		
4	202733	D4930-3P	D4930 Rev B			Bearpaw - cut blanks as per D4930-3 file	Firmed X6		11/15/19	8 Ea	0 Ea	8 Ea	\$25.61/Ea	\$204.88
												NOV 11 2019		
5	202732	D4930-1P	D4930 Rev B			Bearpaw - cut blanks as per D4930-1 file	Firmed X4		11/15/19	4 Ea	0 Ea	4 Ea	\$23.09/Ea	\$92.36
												NOV 11 2019		
6	202731	D5377-1P	D5377 Rev A			Bearpaw - cut blanks as per D5377-1 file	Firmed X8		11/15/19	8 Ea	0 Ea	8 Ea	\$48.89/Ea	\$391.12
												NOV 11 2019		
7	202742	D4353-041P	D4353 Rev B			Bearpaw - cut blanks as per D4353-041 file	Firmed X10		11/15/19	10 Ea	0 Ea	10 Ea	\$42.68/Ea	\$426.80
												NOV 11 2019		



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PURCHASE ORDER
POHB044981



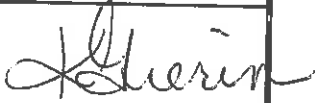
Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	202741	D2521P	D2521 Rev A			Individual Bearpaw - cut blanks as per D2521_BLANK file	Firmed X14	-	11/15/19	14 Ea	0 Ea NOV 11 2019	14 Ea	\$57.77/Ea	\$808.78 KE
9	202740	D4297-1P	D4297 Rev C			Bearpaw - cut blank as per D4297-1 file	Firmed X16	-	11/15/19	6 Ea	0 Ea NOV 11 2019	6 Ea	\$33.18/Ea	\$199.08 KE
10	202737	D2435P	D2435 Rev E1			Bearpaw - cut blank as per D2435 file	Firmed X12	-	11/15/19	12 Ea	0 Ea NOV 11 2019	12 Ea	\$26.45/Ea	\$317.40 KE
Grand Total: \$4,402.18														

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 DOCUMENT SPECIAL REQUIREMENTS
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS



Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/6/19 8:34 AM Dart.Guerin.Kimberley

Acier Duval Steel div. JD Welding Inc.
5888 County Road 17, Plantagenet ON. K0B1L0
Tel: 613-673-4574 -- toll free\ sans frais 1-866-831-5722
info@adsindustries.com www.adsindustries.com

Certificate of Conformance (CoC)

Customer Name	Dart Aerospace
P.O. Number	POHB044981
Part Number	D2432P (Job : 202735)
Drawing Number	D2432 Rev H
Material thickness	1"
Quantity	24
Invoice \ Packing slip #	8123

DAS
81
9-89

All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawing and document

I, as a supplier to Dart Aerospace, acknowledge and certify the material covered under this document is produced in accordance with the following:

The Quantity in the P.O

The Drawing send to the administration

And other document send in regard to the pieces

*(Acknowledge by marking the boxes)

☒
☒
☒

<u>Robert Duval</u>	Quality Management	November 7 2019
Signature	Title	Date

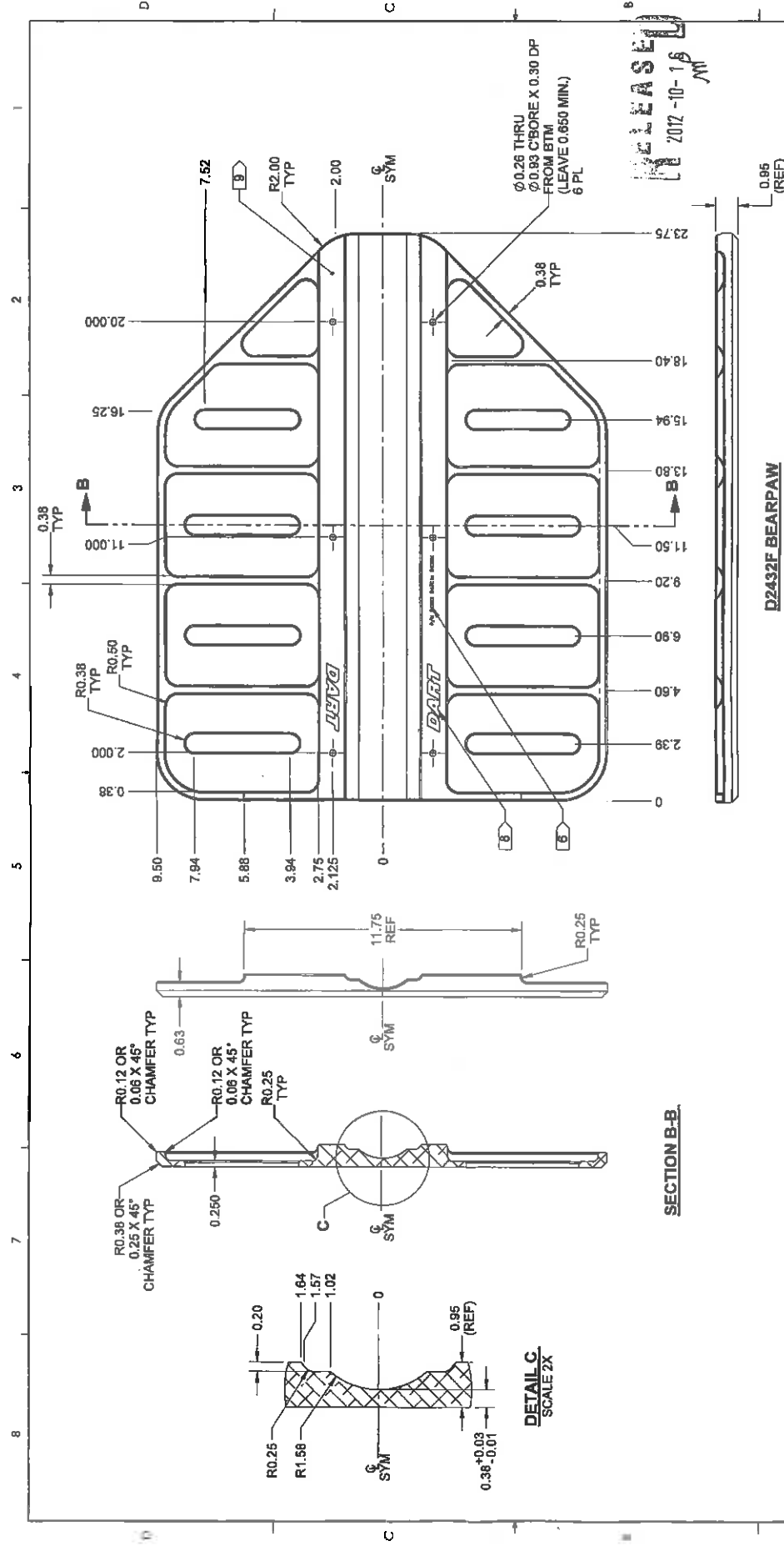
This certifies the parts / items / material identified above conform to all applicable drawing and/or specification as evidenced by report or other documentation on file and all other purchase order and



H	RIB HEIGHTS CHANGED TO CONVENTION OF REV. F. SEE	AP	12.08.24
G	UPDATE DRAWING FORMAT, REMOVED D3432B, ADD D2432-S, ADDING DIMENSION 1.52 (D1-12)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F PIN	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.08.04
C	CHANGE C'BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31

DESIGN	LE	DART AEROSPACE LTD HAWKNESSBURRY, ONTARIO, CANADA DRAWING NO. D2432 TITLE BEARPAW SCALE NTS REV. H SHEET 1 OF 3	RY	DATE
DRAWN	AP			
CHECKED	<i>A.L.S.</i>			
MFG. APPR.	<i>g/j</i>			
APPROVED	<i>MD</i>			
DE APPR.	MD			
DATE	12.09.24			

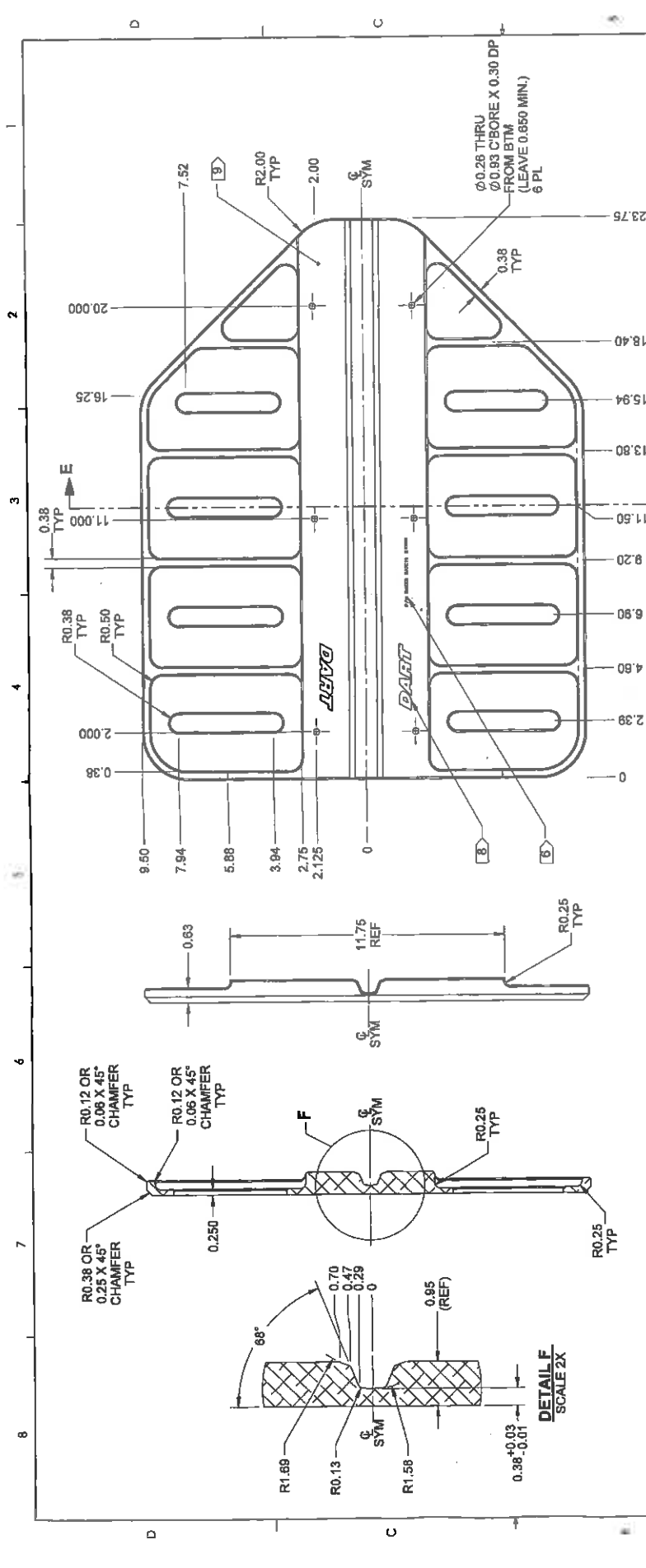
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- NOTES:**
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.850 (REF DART SPEC. MUHWG10)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.008 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "XXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
 - 7) WEIGHT: 5.87 lbs
 - 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
 - 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
 - 10) PROFILE PER DRAWING FILE "D2434F-REV.H,STP"

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2432 TITLE BEARPAW COPYRIGHT © 1986 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DRAWING OR THE INFORMATION CONTAINED HEREIN IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	REV. H SHEET 2 OF 3	SCALE NTS
DRAWN	AP			
CHECKED	<i>ALS</i>			
ENG. APPR.	<i>gdl</i>			
APPROVED	<i>MD</i>			
DATE	12.09.24			

7) WEIGHT: 5.87 lbs.



SECTION E-E

D2432-3 BEARPAW

REVISION
2012-10-16

NOTES:
1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL. 1.000 THICK MACHINED TO 0.950 (REF DART SPEC: MUHMWB10)

2) FINISH: NONE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) TOLERANCES: UNLESS OTHERWISE NOTED

4) UNITS: MILLIMETERS UNLESS OTHERWISE NOTED

5) BREAK: SHARP EDGES: 0.05 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3

7) WEIGHT: 6.25 lbs

8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012

9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED

10) PROFILE PER DRAWING FILE "D2432-3-REV.H.STP"

DESIGN	LE	DART AEROSPACE LTD
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA
CHECKED	ALS	DRAWING NO. D2432
MFG. APPR.	MS	SHEET 3 OF 3
DE APPR.	MS	TITLE BEARPAW
DATE	12.09.24	SCALE NTS

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DART AEROSPACE LTD		Work Order:	202735
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060x45°	✓		Ucr	
B	0.200	+/-0.030	0.200	✓		Ucr	
C	0.25 x 45°	+/-0.030	0.25x45°	✓		Ucr	
D	R0.250	+/-0.030	R0.25	✓		R.G.	
E	0.250	+/-0.010	0.255	✓		Ucr	
F	0.625	+/-0.030	0.635	✓		Ucr	
G	0.375	+0.030/-0.010	0.385	✓		Ucr	
H	0.950	+/-0.030	0.955	✓		Ucr	
I	19.000	+/-0.030	19.00	✓		TAPE	
J	Ø0.260	+0.005/-0.000	0.260	✓		Ucr	
K	Ø0.93	+/-0.030	0.927	✓		Ucr	
L	0.30	+0.030/-0.000	0.310	✓		D.G.	
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.000	✓		Ucr	
O	0.38	+/-0.030	0.38	✓		Ucr	
P							
Q							
R							
S							
T							
U							
V							

Measured by: PAS 52	Audited by: DAS 23	Preliminary Approval:
Date: 9-89 19/11/14	Date: 9-89 19/11/18	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	